Date User:

Thursday, 12/06/2008 3:46:52 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 39848

: 11318

P.O. Number

: 12/06/2008 This Issue

: NC

Prsht Rev. First Issue

: // : 38064

S.O. No. :

Type

: MACHINED PARTS

Previous Run Written By

Checked & Approved By

Comment

04.09.02

Est B 06.05.02 Water jet

New issue KJ/JLM

EC

Drawing Name

: DOUBLER

Part Number

Due Date

: D33023 : D3302 REV B2

Drawing Number Project Number

: N/A : B2

Drawing Revision

Material

: 30/06/2008

Qty:

20 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 .063 Sheet

1.0

M6061T6S063



Comment: Qty.:

1.0428 sf(s)/Unit Total:

20.8551 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick 108279 X 15

(M6061T6S.063)

Identify for D3302-3 Batch: (0738)

2.0

WATER JE



Comment: FLOW WATER JET

1-Cut as per Dwg D3302

188-6-13

Dwg Rev: <u>\$ 3</u> Prog Rev:__

2-Deburr if necessary

3.0

7.A.

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





138.6.13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

cocentas

Dart Ae	rospace l	_td					* *	
W/O:			W	ORK ORDER CHANGES		1 1 1		······································
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•	· .				
	-				***************************************			
Part No	:	PAR #:	Fault Cat	egory: N	ICR: Yes	No DQA:_	Date: _	
					QA: N	C Closed: _	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		• •	WORK OR	DER NON-CONFORMANO	CE (NCR)		\ .
DATE	OTED	Description of NC		Corrective Action Section B	n Section B		on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification C		QC Inspector
		·						

NCR:		· · V	VORK ORD	ER NON-CONFORMANO	CE (NCR)			\	
		Description of NC		Corrective Action Section B			Annessal	al Amprovel	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval .Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

Thursday, 12/06/2008 3:46:52 PM Date: User: Julie Lecocq **Process Sheet Drawing Name: DOUBLER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 39848 Part Number: D33023 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 BRAKE NC NC BRAKE **Comment: NC BRAKE** Form as per Dwg D3302 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4. QC3 9.0 08 -06 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING ' 10.0 Comment: PACKAGING RESOURCE#1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASÉ QC21 11.0 Comment: FINAL INSPECTION/W/O RELEASE C208106123 Job Completion

Dart Ae	rospace	Ltd						
W/O:			V	ORK ORDER CHANGES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•				
Part No	:	PAR #:	Fault Ca	tegory: NC	R: Yes N	lo DQA :	_ Date: _	
					QA: N/	C Closed:	Date:	
NCR:		V	WORK ORI	DER NON-CONFORMANCE	(NCR)			
DATE	CTED	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	gn & Section C Chie		QC Inspector
			1				1	1

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B				Annroval	Annewal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
·										
						:				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39848
Description: Doubler	Part Number:	D3302-3
Inspection Dwg: D3302 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Prototype

X First Article

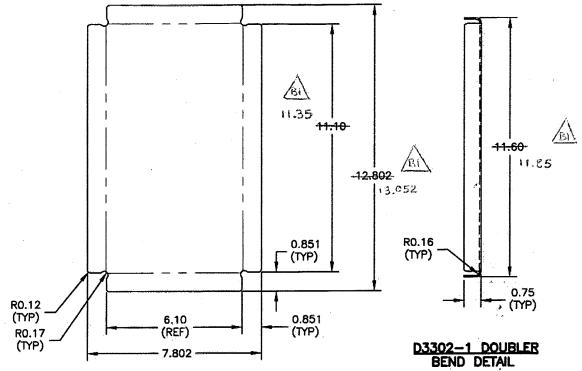
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14,487	×			
12.75	+/-0.030	12.75	×			
0.851	+/-0.010	1881	¥			
0.851	+/-0.010	138,	Ø			
8.952	+/-0.010	8.457	×			
R0.12	+/-0.030	61,	Á			
7.250	+/-0.010	7.245	*			
			,			

Measured by:	Audited by:		Prototype Approval:	N/A
Date: 8-6-13	Date:	8/66/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
В	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM -	
С	07.01.16	Dimensions revised	KJ/JLM ,	1
D	07.01.29	Dimensions revised	KJ/JLM ح	

DELEASED

	DESIG	P#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
ı	CHECH	(ED M	APPROVED	DRAWING NO. REV. E
		-11	-#	D3302 SHEET 1 OF 4
	DATE		·	TITLE SCALE
	04.1	04.11.18		DOUBLER 1:4
	Α		04.07.06	NEW ISSUE
	B		04.11.18	REMOVE HOLES
	Bi	A P	F 04.12.15	ADDED 0.25" TO THE LEWETH FOR -1/-3
	B2	#	(इ.१३) के	7.25 WAS 7.34 : 8.952 WAS 9.042 ; 7:75 WAS 7.84 FOR 33302-3



D3302-1 FLAT PATTERN

- 6.60 0.75 (TYP) R0.16 (TYP)

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3302-1 NOTES:

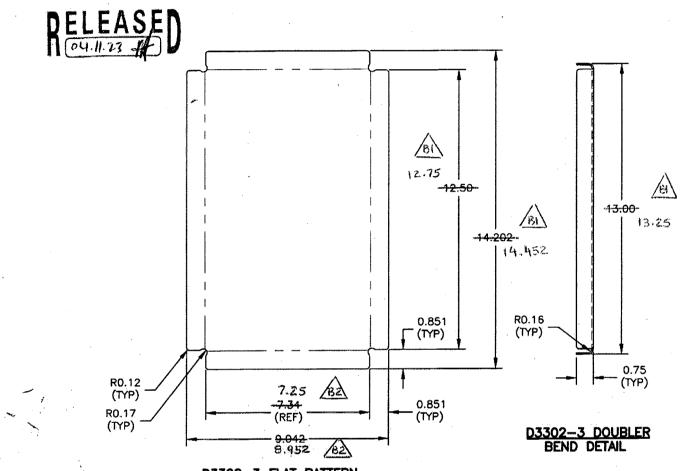
- MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010 ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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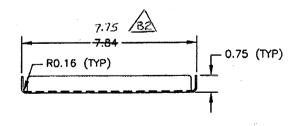
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#	1 #	D3302	SHEET 2 OF 4
DATE	* ***	TITLE	SCALE
04.11.18		DOUBLER	1:4



D3302-3 FLAT PATTERN



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D3302-3 NOTES:

- MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

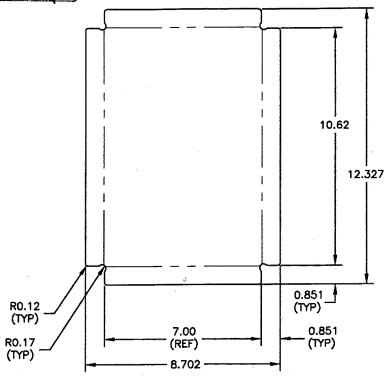
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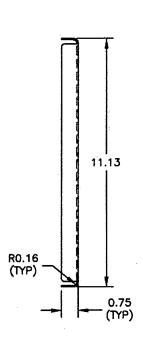
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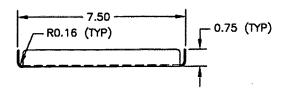
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#	 	D3302	SHEET 3 OF 4
DATE		TITLE	SCALE
04.11.08		DOUBLER	1:4

RELEASED





D3302-5 FLAT PATTERN



D3302-5 DOUBLER BEND DETAIL

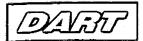
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D3302-5 NOTES:

- MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

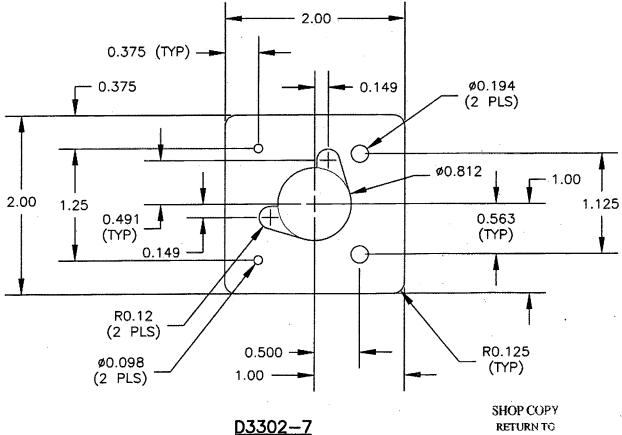
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CHECKED	APPROVED	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1;1





ENGINEERING

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SUBJECT TO AMENDMEN!

WITHOUT NOTICE

WORK QRDER

D3302-7 NOTES: 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

- 4) ALL DIMENSIONS ARE IN INCHES
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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